Date:

Thursday, 14/05/2009 3:41:17 PM

User:

Julie Dawson

**Process Sheet** 

Customer **Job Number**  : CU-DAR001 Dart Helicopters Services

**Drawing Name** 

: MOUNTING ANGLE

**Estimate Number** 

P.O. Number

: 47966 : 10509

: 14/05/2009 S.O. No. : Part Number

: D2564

This Issue

**Drawing Number** 

: D2564 REV. B1

: NC Prsht Rev.

: //

Project Number

: N/A

First Issue : 45243 **Previous Run** 

: MACHINED PARTS Type

**Drawing Revision** 

: B1

: 21/05/2009

Material **Due Date** 

Qty:

50 Um:

Each

Written By

Checked & Approved By Comment

: Est:D 02.09.09

Re-format; Added FA276 Folio KJ/RF

**Additional Product** 

Job Number:



Seq. #:

Description:

1.0

D6207

Angle Extrusion



Comment: Qty.:

0.0962 f(s)/Unit

Total: 4.8090 f(s)

Angle Extrusion

Material: D6207 (1" x 1" x .125 angle) 6061-T6/T6511 (QQ-A-200/8)

(D6207)

2.0

BAND SAW

Comment: BAND SAW

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Cut D6207 Extrusion: 1.00" Long (+0.000/-0.030)

3.0

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA276 Rev: 1/4 & Dwg D2564 Rev: B1

2-Deburr if necessary

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACI



5.0

SECOND CHECK



Comment: SECOND CHECK





### **Dart Aerospace Ltd**

|                                       |      |                   |                                | · ·                          |                |              |            |                               |                          |  |
|---------------------------------------|------|-------------------|--------------------------------|------------------------------|----------------|--------------|------------|-------------------------------|--------------------------|--|
| W/O:                                  |      |                   | W                              | ORK ORDER CHANG              | ES             |              |            |                               |                          |  |
| DATE                                  | STEP | PRO               | PROCEDURE CHANGE               |                              |                |              | Qty        | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
| · · · · · · · · · · · · · · · · · · · |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      | PAR #:            | Fault Category: NCR: Yes No DC |                              |                | No <b>DQ</b> | DQA: Date: |                               |                          |  |
| Resolution:                           |      |                   | Dispositio                     | n:                           | _ QA: N/C Cld  | osed:        |            | Date: _                       |                          |  |
| NCR:                                  |      |                   | WORK ORD                       | ER NON-CONFORMA              | NCE (NCR       | )            |            |                               |                          |  |
| DATE                                  | STEP | Description of NC |                                | Corrective Action Section    |                | ation        |            | Approval                      |                          |  |
|                                       |      | Section A         | Initial<br>Chief Eng           | Action Description Chief Eng | Sign &<br>Date | Secti        | on C       | Chief Eng                     | QC Inspector             |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |
|                                       |      |                   |                                |                              |                |              |            |                               |                          |  |

Thursday, 14/05/2009 3:41:17 PM Date: User: Julie Dawson **Process Sheet** Drawing Name: MOUNTING ANGLE Customer: CU-DAR001 Dart Helicopters Services Part Number: D2564 Job Number: 47966 Job Number: Seq. #: **Description: Machine Or Operation:** PACKAGING RESOURCE #1 PACKAGING 1 6.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location:\_ FINAL INSPECTION/W/O RELEASE 7.0 QC21 Comment: FINAL INSPECTION/W/O RELEASE Job Completion

# **Dart Aerospace Ltd**

| W/O:     |      | WORK ORDER CHANGES             |                  |                    |                        |        |                     |     |                               |                          |  |  |
|----------|------|--------------------------------|------------------|--------------------|------------------------|--------|---------------------|-----|-------------------------------|--------------------------|--|--|
| DATE     | STEP | PR                             | PROCEDURE CHANGE |                    |                        |        |                     | Qty | Approval Chief Eng / Prod Mgr | Approval<br>QC Inspector |  |  |
|          |      |                                |                  |                    |                        |        |                     |     |                               |                          |  |  |
|          |      |                                |                  |                    |                        |        |                     |     |                               |                          |  |  |
| Part No: |      | PAR #:                         | Fault Catego     | NCI                | NCR: Yes No DQA: Date: |        |                     |     |                               |                          |  |  |
|          | R    | esolution:                     | Disposition:     |                    | QA                     | N/C CI | osed:               |     | Date:                         | <del></del>              |  |  |
| NCR:     |      |                                | WORK ORDER       | NON-CONFOR         | RMANCE                 | (NCR   | )                   |     |                               |                          |  |  |
| DATE     | STEP | Description of NC<br>Section A | Initial          | Action Description | ription Sign &         |        | Verifica<br>Section |     | Approval Chief Eng            | Approval<br>QC Inspector |  |  |
|          |      |                                | Chief Eng        | Chief Eng          |                        | Date   | 00010               |     | 55. <u>2</u> g                | do moposion              |  |  |
|          |      |                                |                  |                    |                        |        |                     |     |                               |                          |  |  |
|          |      |                                |                  |                    |                        |        |                     |     |                               |                          |  |  |
|          |      |                                |                  |                    |                        | :      |                     |     |                               |                          |  |  |
|          | j    |                                | 1                |                    |                        | }      |                     |     | l                             |                          |  |  |
|          |      |                                |                  |                    |                        |        |                     |     |                               |                          |  |  |

| DART AEROSPACE LTD            | Work Order:  | 47966       |
|-------------------------------|--------------|-------------|
| Description: Mounting Angle   | Part Number: | D2564       |
| Inspection Dwg: D2564 Rev: B1 |              | Page 1 of 1 |

## FIRST ARTICLE INSPECTION CHECKLIST

| Х | First Article | Prototype |
|---|---------------|-----------|
|   |               |           |

| Drawing<br>Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of<br>Inspection | Comments |
|----------------------|-----------|------------------|--------|--------|-------------------------|----------|
| 1.00                 | +/-0.030  | 1.004            |        |        |                         |          |
| 0.625                | +/-0.010  | . 623            |        |        |                         |          |
| Ø0.257               | +/-0.010  | 6.260            |        |        |                         |          |
| 1.000                | +/-0.010  | 1.00%            |        | -      |                         |          |
| 1.000                | +/-0.010  | 1.004            | /      |        |                         |          |
| R0.375               | +/-0.010  | R.375            |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        | ı      |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |
|                      |           |                  |        |        |                         |          |

|              |          |             | <b>\</b> |                     |     |
|--------------|----------|-------------|----------|---------------------|-----|
| Measured by: | All      | Audited by: | 21       | Prototype Approval: | N/A |
| Date:        | 89/05/25 | Date:       | 07/03/25 | Date:               | N/A |

| Rev | Date     | Change    | Revised by | Approxed |
|-----|----------|-----------|------------|----------|
| Α   | 04.06.10 | New Issue | KJ/JLM     |          |

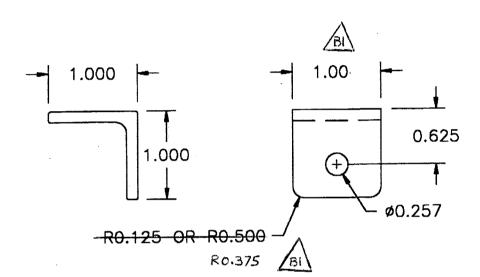
| Dart Ae     | rospace L   | td                             |                     |                                             |             |        |                           |                                     |                          |  |  |
|-------------|-------------|--------------------------------|---------------------|---------------------------------------------|-------------|--------|---------------------------|-------------------------------------|--------------------------|--|--|
| W/O:        |             |                                | WORK ORDER CHANGES  |                                             |             |        |                           |                                     |                          |  |  |
| DATE        | STEP        | PR                             | OCEDURE CHAN        | IGE                                         | 1           | Ву     | Date Qty                  | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |  |
|             |             |                                |                     |                                             |             |        |                           |                                     |                          |  |  |
|             |             |                                |                     |                                             |             |        |                           |                                     |                          |  |  |
|             |             |                                |                     |                                             |             |        |                           |                                     |                          |  |  |
|             |             |                                |                     |                                             |             |        |                           |                                     |                          |  |  |
| Part No     | Part No:PAR |                                | Fault Categ         | ory:                                        | NCR:        | Yes N  | lo DQA:                   | _ Date: _                           |                          |  |  |
| Resolution: |             | Disposition                    | Disposition: QA: N/ |                                             | N/C Closed: |        | Date: _                   |                                     |                          |  |  |
| NCR:        |             |                                | WORK ORDE           | R NON-CONFORM                               | IANCE (     | (NCR)  |                           |                                     |                          |  |  |
| DATE        | STEP        | Description of NC<br>Section A | Initial             | Corrective Action Sec<br>Action Description | t e         | Sign & | Verification<br>Section C | Approval<br>Chief Eng               | Approval<br>QC Inspector |  |  |

| NCR: WORK ORDER NON-CON |      |                   |                      |                              | CE (NCR)       |                           |                       |              |
|-------------------------|------|-------------------|----------------------|------------------------------|----------------|---------------------------|-----------------------|--------------|
| D.4.T.F                 |      | Description of NC |                      | Corrective Action Section B  |                |                           | Approval              | Approval     |
| DATE                    | STEP | Section A         | Initial<br>Chief Eng | Action Description Chief Eng | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | QC Inspector |
|                         |      |                   |                      |                              |                |                           |                       |              |
|                         |      |                   |                      |                              |                |                           |                       |              |
|                         |      |                   |                      |                              |                |                           |                       | ·            |
|                         |      |                   |                      |                              |                |                           |                       |              |
|                         |      |                   |                      |                              |                |                           |                       |              |
|                         |      |                   |                      |                              |                |                           |                       |              |
| ٠,                      |      |                   |                      |                              |                |                           |                       |              |
|                         |      |                   |                      |                              |                |                           |                       |              |
|                         |      |                   |                      |                              |                |                           |                       |              |
|                         |      | •                 |                      |                              | Į.             |                           | 1                     | ł .          |



|       | DESIGN DRAWN BY MIKE M MIKE M |          | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA |          |  |  |  |  |  |
|-------|-------------------------------|----------|-----------------------------------------------------------|----------|--|--|--|--|--|
| CHECK |                               | APPROVED | DRAWING NO.                                               | REV. B   |  |  |  |  |  |
| B     | W                             | BW       | D2564 SHEE                                                | T 1 OF 1 |  |  |  |  |  |
| DATE  |                               | L        | TITLE                                                     | SCALE    |  |  |  |  |  |
| 96:0  | 04:30                         |          | MOUNTING ANGLE                                            | 1:1      |  |  |  |  |  |
| В     |                               | 97:05:06 | MODIFIED DIMENSIONS                                       |          |  |  |  |  |  |
| Bi    | diR                           | 02.09.17 | RO.375 WAS RO.125 CR RO.500 ;                             |          |  |  |  |  |  |
|       | 44                            |          | 1.00 WAS 1.000                                            |          |  |  |  |  |  |

RELEASE D



#### NOTES:

- I) MATERIAL: 6061-T6 ANGLE 1.0 X 1.0 X 0.125

  MAKE FROM D 6207-XXX ANGLE EXTRUSION
- 2) BREAK ALL SHARP EDGES 0.005 0.015
- 3) TOLERANCES PER DART OSI DIS UNLESS OTHERWISE NOTEL
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

#### **Dart Aerospace Ltd**

| W/O:    |      | WORK ORDER CHANGES |                   |                              |        |                |        |                |                                     |                          |  |
|---------|------|--------------------|-------------------|------------------------------|--------|----------------|--------|----------------|-------------------------------------|--------------------------|--|
| DATE    | STEP | PROCEDURE CHANGE   |                   |                              |        | Ву             | Date   | Qty            | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|         |      | ·                  |                   |                              |        |                |        |                |                                     |                          |  |
|         |      |                    |                   |                              |        |                |        |                |                                     |                          |  |
|         |      |                    |                   |                              |        |                |        |                |                                     |                          |  |
| Part No | :    | PAR #:             | Fault Cated       | orv:                         | NCR    | : Yes I        | No DQ  | <br><b>A</b> : | Date:                               |                          |  |
|         |      | solution:          |                   |                              |        |                |        |                | •                                   |                          |  |
| NCR:    |      |                    | WORK ORDE         | R NON-CONFORM                | ANCE   | (NCR           |        |                |                                     |                          |  |
| DATE    | STEP | Description of NC  |                   |                              | tion B |                | Verifi | cation         | Approval                            | Approval                 |  |
| DATE    | SIEF | Section A          | Initial Chief Eng | Action Description Chief Eng |        | Sign &<br>Date |        | ion C          | Chief Eng                           | QC Inspector             |  |
|         |      |                    |                   |                              |        |                |        |                |                                     |                          |  |
|         |      |                    |                   |                              |        |                |        |                |                                     |                          |  |
|         |      |                    |                   |                              |        |                |        |                |                                     |                          |  |
|         |      |                    |                   |                              |        |                |        |                |                                     |                          |  |
|         |      |                    |                   |                              |        | :              |        |                |                                     |                          |  |
|         |      |                    |                   |                              | Į      |                |        |                | 1                                   |                          |  |